



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G09132-3G-PO

Job Sheet 190915



Part No: RBW6205G09132-3G-PO

Job Qty: 2 pcs

Part Name: Trolley Adapter, Swashplate Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/19/19

Job Tracking No:

Due Date: 3/26/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G09132-3G Rev 3 IPP Rev A outsource 18.09.18 DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	2 pcs	3/26/19	0.00	0.00		Purchasing - 1	MAR 12 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	2 pcs	3/26/19	0.00	0.00		Packaging 2 - 1 - B4B	MAR 12 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



Container No: S161615



Part: RBW6205G09132-3G

Job No: 190915

Serial No/Batch: S161615

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/12/19

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	2 pcs	3/26/19	0.00 0.00		QC 6 - 42	
					QC 6 - 9	DAS
					QC 6 - 68	MAR 14 2019 68
					QC 6 - 61	9-89
130 Small Fab - 2 - B4B	2 pcs	3/26/19	0.00 1.00		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	MLL
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
140 QC 5	2 pcs	3/26/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	DAS
					QC 5 - 68	MAR 15 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
150 Packaging 3-1 - Stock - B4B	2 pcs	3/26/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
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					Packaging 3 - 28 - B4B	
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					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

160 QC 21 - FG

2 pcs

3/26/19

0.00 0.00

DAS
21
3-25

MAR 19 2019

Part Op **100** - Purchasing - Issue PO to ARROW TECH MACHINE WORKS P/O: 042653 MANUFACTURE
 Descriptions: RBW6205G09132-3G AS PER DWG -Certificate of conformity is required
110 - Receive & Inspect for Damage & Mat'l Certs
120 - QC6- All purchased or subcontracted products
130 - Small Fab - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into RBW6205G09132-3G. 3-Install placard using drive screws. .
140 - QC5- Inspect part completeness to step on W/O
150 - Identify as per dwg & Stock Location: _____
160 - QC21- Final Inspection - Work Order Releas

x2 hho 19 Feb 2019.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G09132-3GP	Trolley Adapter, Swashplate Support	2 pcs (1 ea)	100-Purchasing	5161614
91654A076	Drive Screw #2 3/16" Long	8 Ea (4 ea)	130-Small Fab - 2 - B4B	5015391
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	130-Small Fab - 2 - B4B	5021040

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G09132-3GP	2	0	0
130-Small Fab - 2 - B4B	91654A076	8	32	0
	RB41011	2	416	0

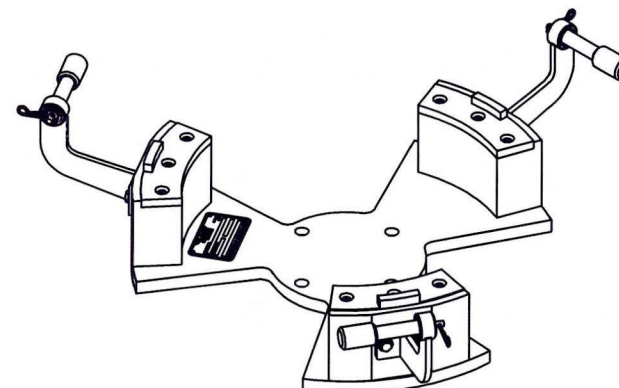
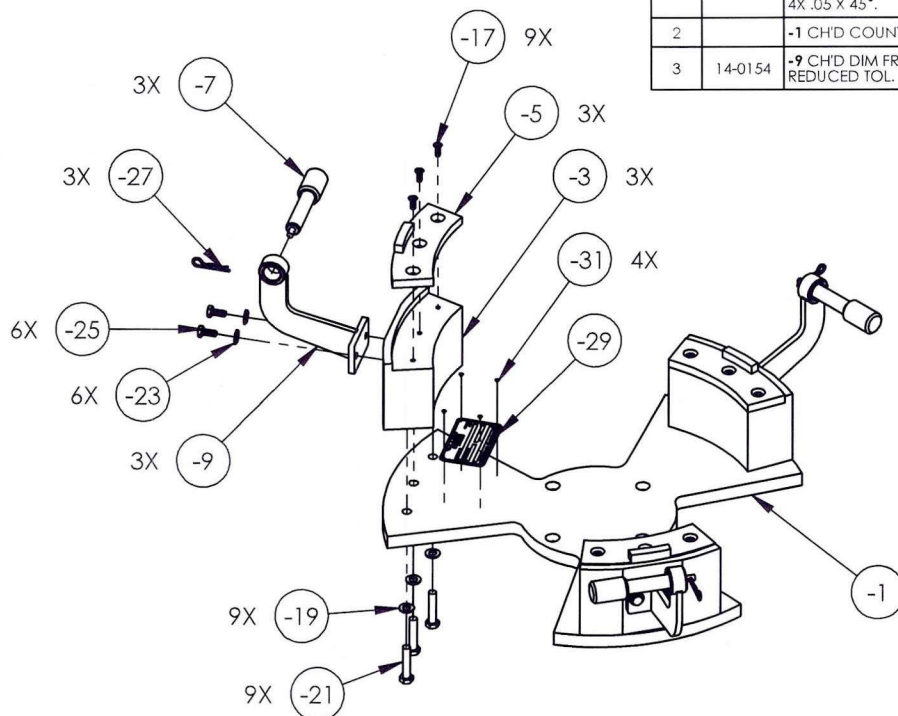
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 CH'D COUNTERBORE WAS .594 ∇ .390 IS .594 ∇ .39. -3 CH'D HOLE DEPTHS WAS .394 IS .39. WAS 1.000 IS 1.00. WAS .625 IS .63. -7 ADDED NOTE "CENTER OK". -13 CH'D CHAMFER WAS 4X .050 X 45° IS 4X .05 X 45°.	6/25/2013	BIM	GE
2		-1 CH'D COUNTERBORE HOLES FROM $\varnothing$ 5.375 B.C. TO $\varnothing$ 5.512 B.C.	7/19/2013	RJC	RW
3	14-0154	-9 CH'D DIM FROM 4.164 TO 3.92. -11 CH'D DIM FROM 4.562 TO 4.32. UPDATE TITLE BLOCK TO DART, REDUCED TOL. ON NON-CRITICAL DIMS.	9/19/2014	JAG	DW



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	6061	5/8 X $\varnothing$ 18-3/4	2
			-3	3	BLOCK	6061	2-3/8 X 3-5/8 X 6-3/8	3
			-5	3	WEAR PLATE	WHITE NYLON	1 X 2-5/16 X 6-1/8	4
			-7	3	PIN	6061	$\varnothing$ 1 X 4-3/4	5
	X		-9	3	ARM WELDMENT			6
	1		-11		ARM	1018	1/4 X 4-1/4 X 4-1/2	7
	1		-13		RING	1018	$\varnothing$ 1-3/16 X 7/8	8
	1		-15		PLATE	1018	3/8 X 1-5/8 X 2-1/2	9
		B/O	-17	9	FLATHEAD SCREW	STEEL	M5 X .8 X 14mm MCMaster-CARR #91420A324	1
		B/O	-19	9	WASHER	STEEL	M8 MCMaster-CARR #91166A270	1
		B/O	-21	9	SCREW	STEEL	M8 X 1 X 40mm MCMaster-CARR #91180A540	1
		B/O	-23	6	WASHER	STEEL	1/4 MCMaster-CARR #90126A029	1
		B/O	-25	6	SCREW	STEEL	1/4-20 X 5/8 MCMaster-CARR #92620A539	1
		B/O	-27	3	HAIRPIN COTTER PIN	STEEL	MCMaster-CARR #98335A058	1
		B/O	-29	1	DART PLACARD	ALUMINUM	RB41011	1
		B/O	-31	4	#2 DRIVE SCREW	COATED STEEL		1
ASSY	-9							

NOTE:
ENGRAVE -29 PLACARD WITH T/N, S/N, "MADE IN USA".

DART AEROSPACE	
TITLE TROLLEY ADAPTER, SWASHPLATE SUPPORT	
DWG NO. RBW6205G09132-3G	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1	DRAWN BY: GILBERT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AW139
SCALE 1:8	DATE 1/19/2012
SHEET 1 OF 9	



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER **PO042653**



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Ship To:

PO No: PO042653
PO Date: 2/19/19
Due Date: 3/26/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	190915	RBW6205G09132-3GP			Trolley Adapter, Swashplate Support REV 3	Firmed	-	3/26/19	2 pcs	0 pcs	2 pcs	\$2,698.00/pcs	\$5,396.00
Grand Total:													\$5,396.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

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2/19/19 AUB



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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042653



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO042653
PO Date: 2/19/19
Due Date: 3/26/19
Purchase Order
Revision:
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Ship-To Contact: Lussier, Patrick

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Grand Total:													\$5,396.00

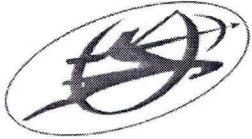
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- A049 SUPPLIER AWARENESS

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**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 458

Date: 3/8/2019 ✓
PO Ref: 042653 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

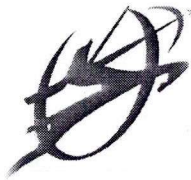
Qty ✓	Item	Part No. ✓
2 ✓	TROLLEY ADAPTER, SWASHPLATE SUPPORT	RBW6205G09132-3G ✓

Received by:

Packaged by: J.M.L.

Checked by: AM

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 042653 ✓ Dated: 3/8/2019

Our Order / Job No: 042653-1AWT Order Qty: 2 ✓

Part Name: TROLLY ADAPTER, SWASHPLATE SUPPORT

Part Number: RBW6205G09132-3G ✓

Lot Size: N/A Ship Date: 3/8/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6205G09132-3G Rev: 3

Material Size and Type: -1,-3-7/6061, -5/WHITE NYLON,-11,-13,-15/ 1018

Material Specifications: ALUM.: ASTM B221; NYLON: D5989; STEEL: ASTM A108, ASTM A29,

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS I ZINC PLATE ASTM B633 TYPE I SC 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 3/8/19

Signed: Henat m. Sakh

DAS
68
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com